

Split

shp Oct. 25!

Work Order ID 91386-2

October-05-12 11:36:46 AM

\*91386\*

Page 1

Item ID: D4410-7

Revision ID:

Item Name: Conduit

Start Date: 10/05/12

Start Qty: 12.00

Required Date: 10/12/12

Req'd Qty: 12.00

Reference:

Accept

\*N9000040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan:

MLJ

Date: 12-10-05

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4410

REV B

100

\*100\*

Small Fab

Small Fab

Memo

BEND AS PER DWG

DEBURR

0.00

0.00

4 0 FF 12-10-19

110

\*110\*

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Smb 12-10-19

4

120

\*120\*

Packaging

Packaging

Identify as per dwg &amp; Stock Location:

w/g

Memo

0.00

0.00

4

12-10-22



**Work Order ID 91386**

October-05-12 11:36:46 AM

**\*91386\***

Page 2

Item ID: D4410-7

Revision ID:

Item Name: Conduit

Start Date: 10/05/12 Start Qty: 12.00

Required Date: 10/12/12 Req'd Qty: 12.00

Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center ID

130

**\*130\***

QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Memo

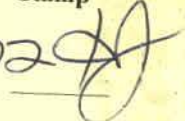
Set Up/  
Run Hours

0.00

0.00

Tool ID

Tool #

Part  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp12/10/22 ME  
12-10-22





# Picklist Print

October-05-12 11:36:46 AM

Page 1

Work Order ID: 91386  
Parent Item: D4410-7  
Parent Item Name: Conduit

Start Date: 10/05/12

Required Date: 10/12/12

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 11-11-02 JLM VERIFIED BY:DD  
13 JFS VERIFIED BY:JLM

IPP REV:B AS PER PB6 12-08-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6T0.625W.049  
6061-T6 RD Tube .625 x.049W

Purchased

No

f

63.6252

21.473684

FF 12-10-19

## Location

## Loc Qty

## Loc Code

MAT014

20.244

107967

5.16

118390

15.084

WA035

43.3812

121170

43.3812

100  
25.0516

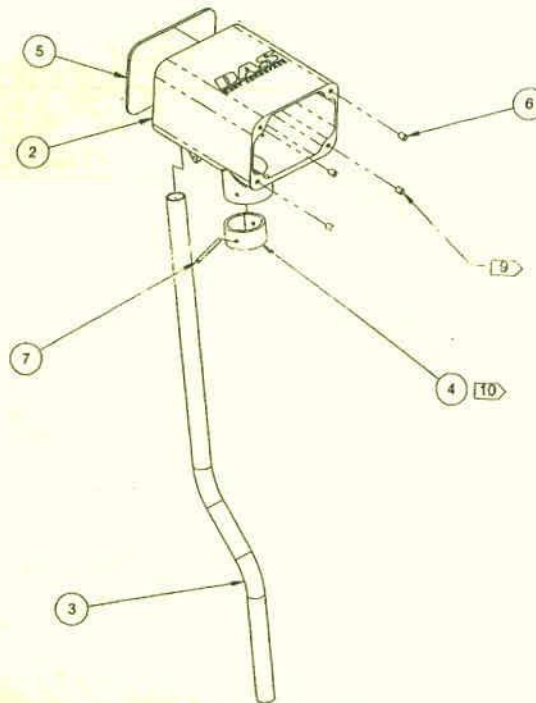




ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4410-041	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)
2	1	D4410-1	CO-PILOT COLLECTIVE HEAD
3	1	D4410-7	CONDUIT
4	1	D4410-11	205 SHIM
5	1	D4410-15	REAR COVER
6	4	90296A108	HELI-COIL INSERT (6-32 X 0.276)
7	1	MS171539	PIN

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED CC  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 91386 MJS  
12-10-05



**D4410-041 CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)**



**D4410-041 WELDING DETAIL  
(-041 SHOWN, -043/-045 SIMILAR)**

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
  - 7) WEIGHT: 1.55 lbs
  - 8) WELD PER DART QSI 004
  - 9) INSTALL AFTER ANODIZING
  - 10) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN

B	ADD CBORE, ZN A4-2, ENLARGE HOLES, ZN C5-3 & B4-3, UPDATE LOGO, ADD -045-111-13-15, ROTATE HOLE, ZN C3-2, INCREASE .7 DIAMETER, ZN C1-6, REMOVE .9 FROM -041 ASSEMBLY, ZN C5-1.	DC	12.07.30
A	NEW ISSUE	DC	11.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	BC		
DRAWN	BC		
CHECKED	BC		
MFG. APPR.	BC		
APPROVED	BC		
DE APPR.	BC		
DATE	12.07.30		

**DART AEROSPACE USA, INC.**  
KENT, WA

DRAWING NO. **D4410**

TITLE **CO-PILOT COLLECTIVE HEAD**

REV. B

SHEET 1 OF 12

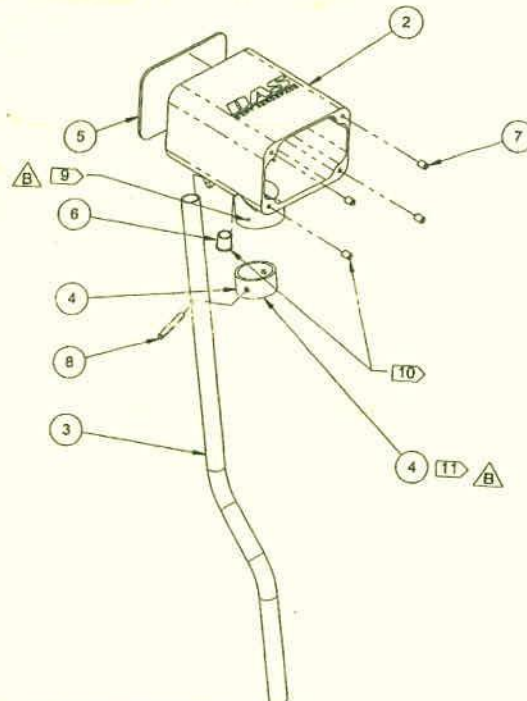
SCALE NTS

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ITEM NO.	QUANTITY	PART NUMBER	DESCRIPTION
1	X	D4410-043	CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)
2	1	D4410-1	CO-PILOT COLLECTIVE HEAD
3	1	D4410-7	CONDUIT
4	1	D4410-13	212 SHIM
5	1	D4410-15	REAR COVER
6	1	D4413-1	DOME PLUG
7	4	90296A108	HELI-COIL INSERT (6-32 X 0.276)
8	1	MS171599	PIN



91386

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
  - 7) WEIGHT: 1.55 lbs
  - 8) WELD PER DART QSI 004
  - 9) REAM TO Ø0.177 (DRILL #16)
  - 10) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT
  - 11) ENSURE THAT PROSEAL DOES NOT CONTACT PIN

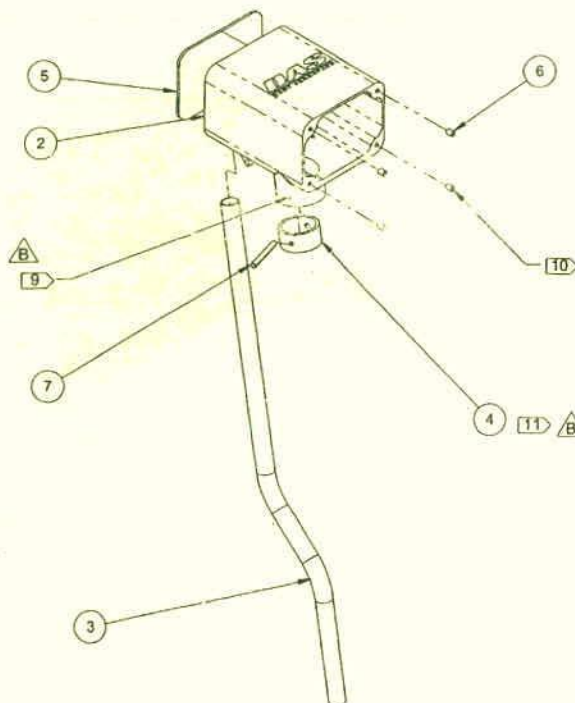
**D4410-043 CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)**

DESIGN	DC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	DC	KENT, WA	
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DC	D4410	SHEET 2 OF 12
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	CO-PILOT COLLECTIVE HEAD	NTS
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ITEM NO.	QTY. -045	PART NUMBER	DESCRIPTION
1	X	D4410-045	CO-PILOT COLLECTIVE HEAD ASSEMBLY (EAGLE SINGLE)
2	1	D4410-1	CO-PILOT COLLECTIVE HEAD
3	1	D4410-7	CONDUIT
4	1	D4410-13	212 SHIM
5	1	D4410-15	REAR COVER
6	4	90296A108	HELI-COIL INSERT (6-32 X 0.276)
7	1	MS171599	PIN



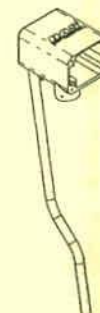
# NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.55 lbs
- 8) WELD PER DART QSI 004
- 9) REAM TO Ø0.177 (DRILL #10)
- 10) INSTALL AFTER ANODIZING
- 11) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN

**D4410-045 CO-PILOT COLLECTIVE HEAD ASSEMBLY  
(EAGLE SINGLE)**

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CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DC	D4410	SHEET 3 OF 12
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	CO-PILOT COLLECTIVE HEAD	NTS
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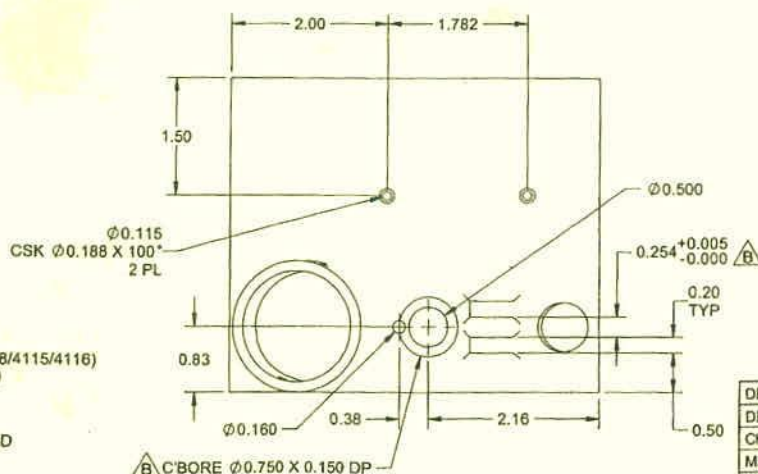
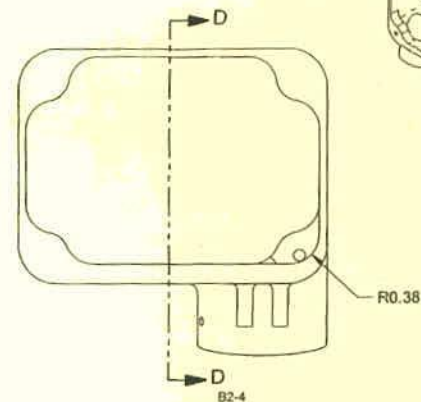
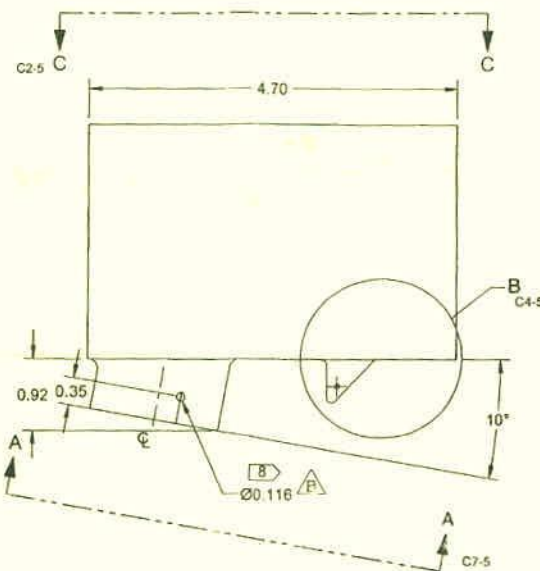
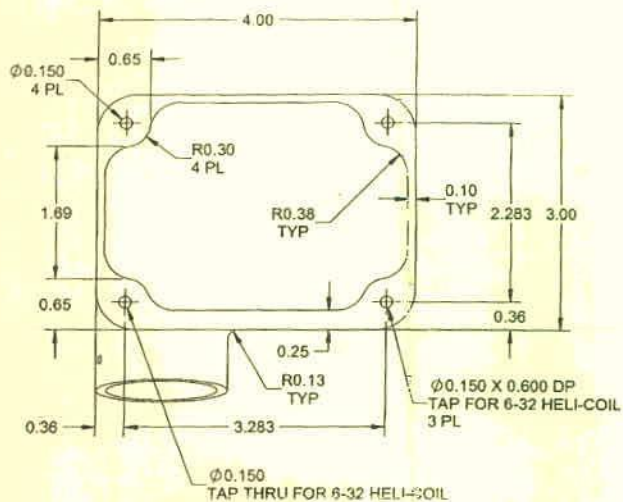
91386



RELEASE  
2012-09-28







- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF. DART SPEC. M6061T6B4.000X3.000
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
  - 7) WEIGHT: 1.24 lbs
  - 8) HOLE IS ROTATED 20° COUNTER-CLOCKWISE WHEN VIEWED FROM ABOVE

# D4410-1 CO-PILOT COLLECTIVE HEAD

## SECTION D-D

D2-4

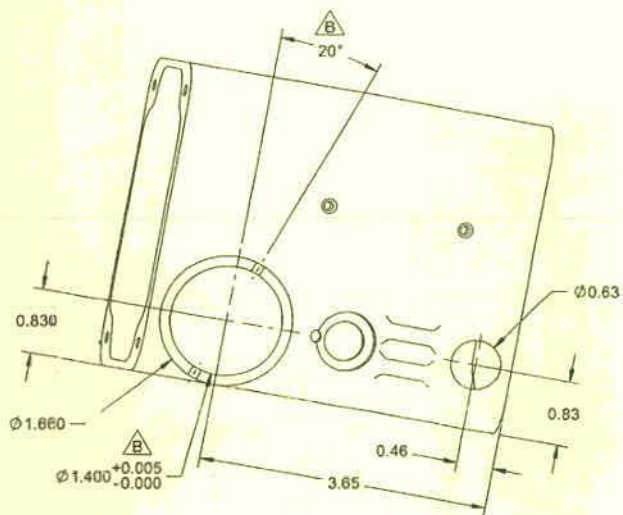
RELEASE  
2012-09-28 L  
JWP

DESIGN	DC	DART AEROSPACE USA, INC.	
DRAWN	DC	KENT, WA	
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DC	D4410	SHEET 4 OF 12
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	CO-PILOT COLLECTIVE HEAD	NTS
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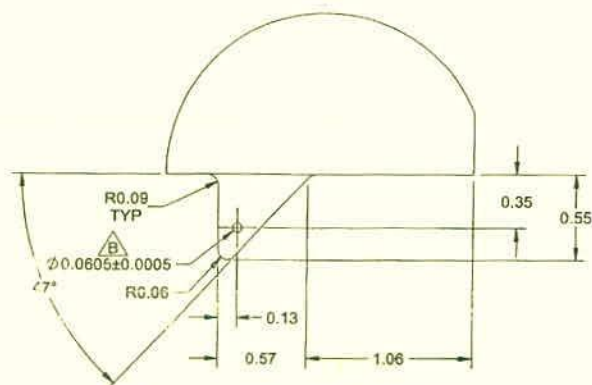




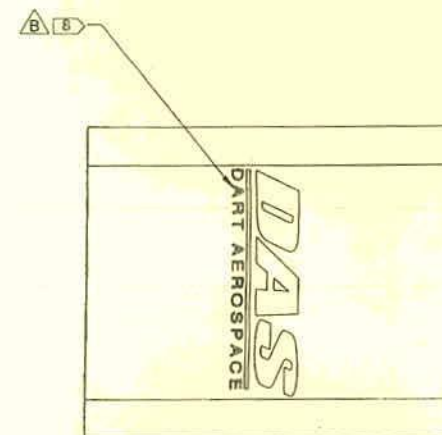
91386



**VIEW A-A**  
C5-4



**DETAIL B**  
C4-4



**VIEW C-C**  
D4-4

**D4410-1 CO-PILOT COLLECTIVE HEAD  
DETAIL VIEWS**

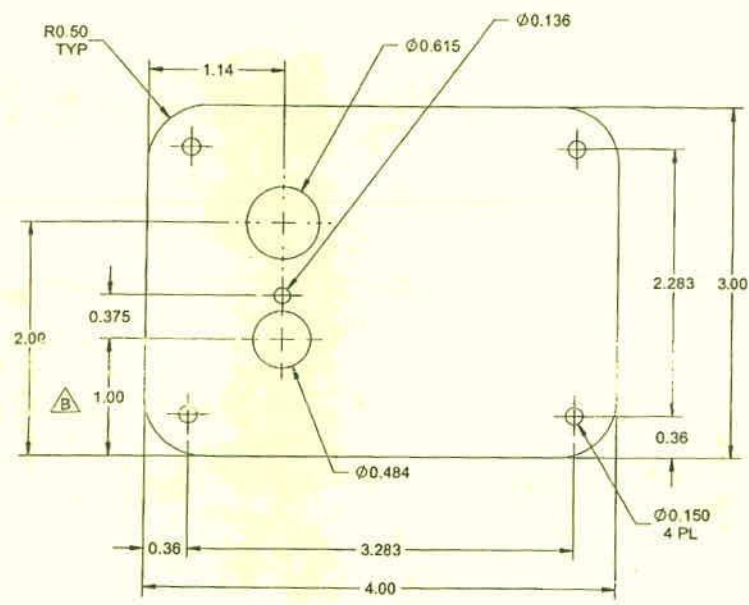
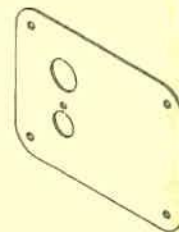
RELEASED  
2012-09-23

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: N/A
  - 8) ENGRAVE "DAS" LOGO AS SHOWN 0.003 - 0.005 DP.

DESIGN	BC	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	BC		
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	BC	D4410	SHEET 5 OF 12
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91386



**D4410-3 FACE PLATE**

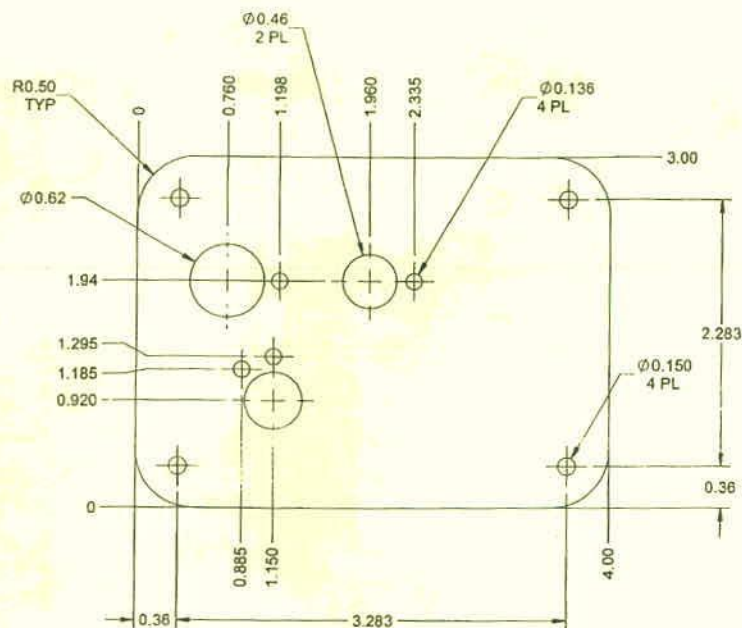
**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THK  
 QQ-A-250/11 OR AMS-QQ-A-250/11  
 OR AMS 4025 OR AMS 4027  
 OR ASTM B209  
 REF. DART SPEC. M6061T6S.040
- 2) FINISH: ANODIZE BLACK PER MIL-A-8825F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

DESIGN	DC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	DC	KENT, WA	
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DC	D4410	SHEET 6 OF 12
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	CO-PILOT COLLECTIVE HEAD	NTS
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**D4410-5 FACE PLATE**

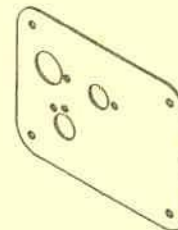
**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THK  
QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF. DART SPEC. M6061T6S.040
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

DESIGN	DC	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	DC		
CHECKED	BE	DRAWING NO.	REV. B
MFG. APPR.	SH	D4410	SHEET 7 OF 12
APPROVED	AD	TITLE	SCALE
DE APPR.	HA	CO-PILOT COLLECTIVE HEAD	NTS
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**RELEASED**  
2012-09-28  
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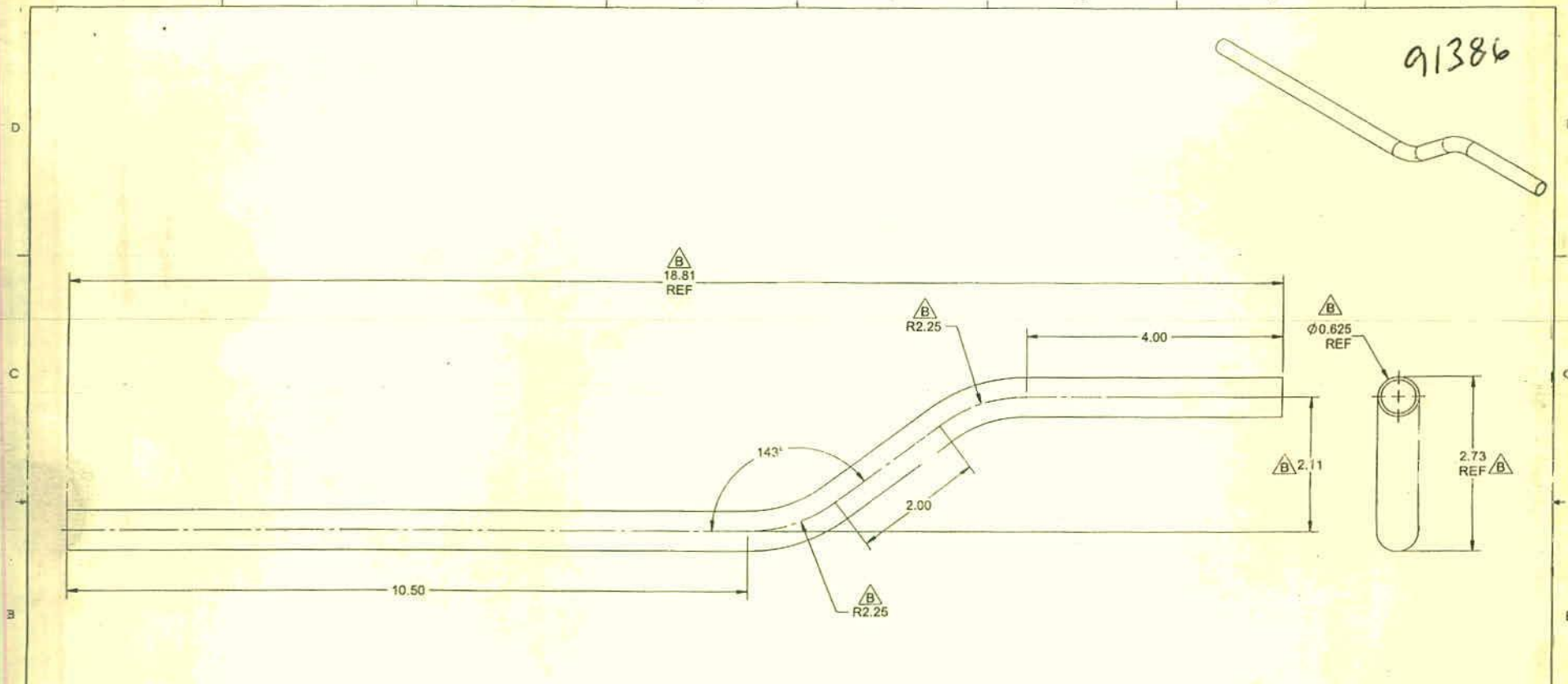
91386







91386



**D4410-7 CONDUIT**

RELEASED  
2012-09-28  
JMP

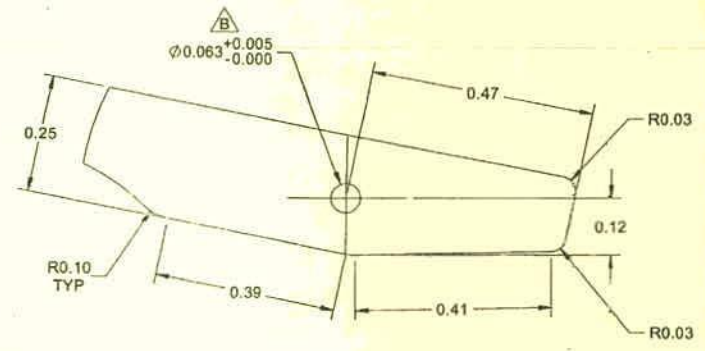
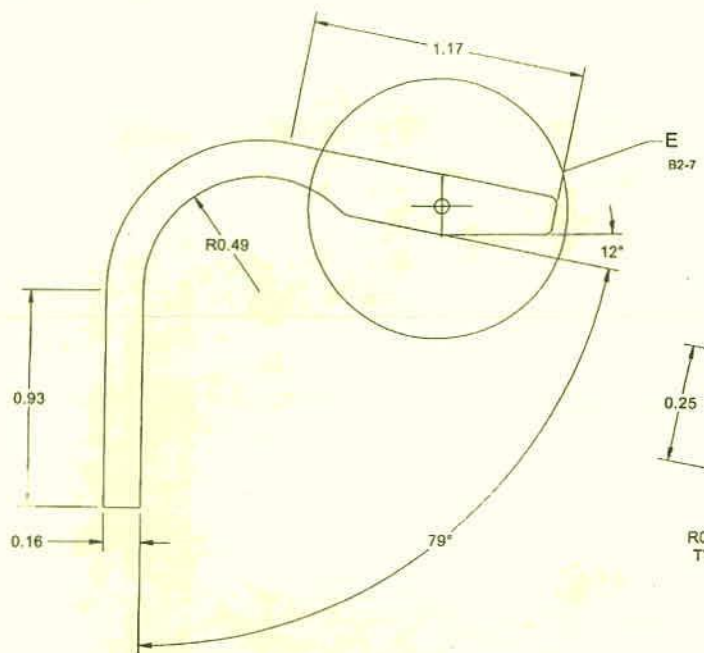
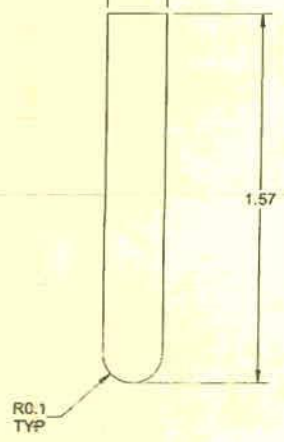
**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T82 ALUMINUM TUBING PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 REF. DART SPEC. M6061T60.625W.050  $\triangle B$
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.17 lbs

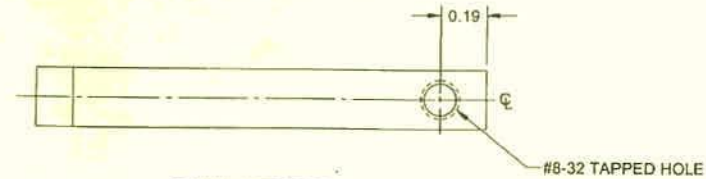
DESIGN	DC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	DC	KENT, WA	
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DC	D4410	SHEET 8 OF 12
A*PROVED	DC	TITLE	SCALE
DE APPR.	DC	CO-PILOT COLLECTIVE HEAD	NTS
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0.250<sup>+0.000</sup>  
REF  
-0.005



DETAIL E  
D4-7



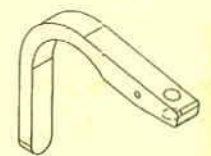
D4410-9 TRIGGER

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.250 THK  
QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF. DART SPEC. M6061T6S.250
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

DESIGN	DC	DART AEROSPACE USA, INC.	
DRAWN	DC	KENT, WA	
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DC	D4410	SHEET 9 OF 12
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	CO-PILOT COLLECTIVE HEAD	NTS
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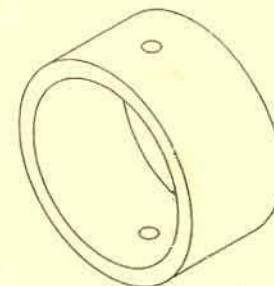
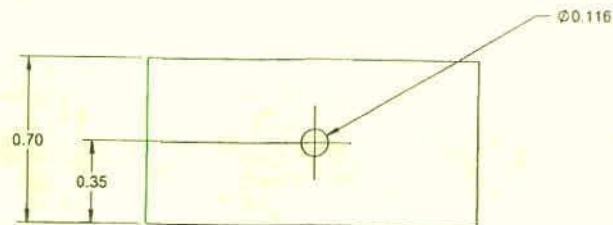
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2012-09-28  
JUN



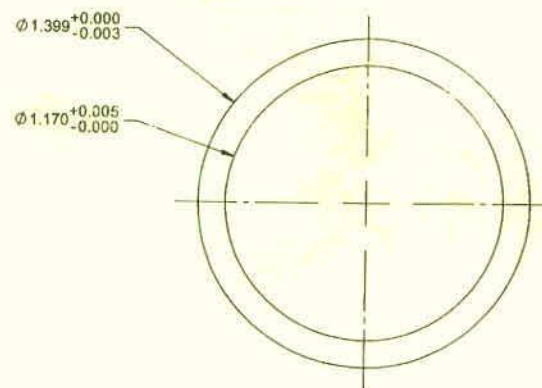
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**D4410-11 205 SHIM**

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2012-09-29  
AMP

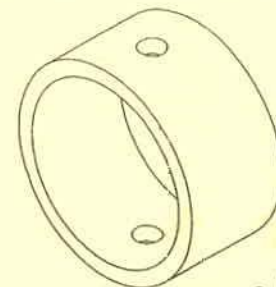
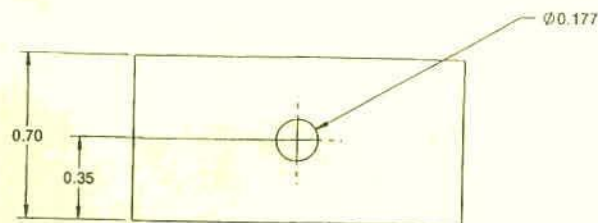
**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM ROUND BAR  
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF. DART SPEC. M6061T6R1.500
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

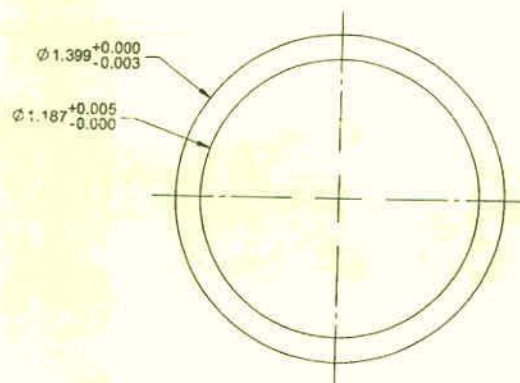
DESIGN	BC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	BC	KENT, WA	
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	BC	D4410	SHEET 10 OF 12
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	CO-PILOT COLLECTIVE HEAD	NTS
DATE	12.07.30	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR CONSIDERED TO BE A PART OF ANY PERSON'S INVENTION WITHOUT PERMISSION FROM DART AEROSPACE USA, INC.</small>	







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**D4410-13 212 SHIM**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR  
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF. DART SPEC. M6061T6R1.500
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

DESIGN	DC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	DC	KENT, WA	
CHECKED	SE	DRAWING NO.	REV. B
MFG. APPR.	ST	D4410	SHEET 11 OF 12
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	CO-PILOT COLLECTIVE HEAD	NTS
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2012-09-28  
WMP



0.100  
REF

R0.50  
TYP

3.938

2.938

**D4410-15 REAR COVER**

**NOTES:**

1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.100 THK  
QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF. DART SPEC. M6061T6S.100

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1

7) WEIGHT: 0.11 lbs

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	SC	KENT, WA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	<b>D4410</b>	SHEET 12 OF 12
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	<b>CO-PILOT COLLECTIVE HEAD</b>	NTS
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